

Date: Friday, 04/04/2008 10:52:08 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	AFT CROSSTUBE
<b>Job Number</b> :	38400		
<b>Estimate Number</b> :	10377		
<b>P.O. Number</b> :		<b>Part Number</b> :	D2890
<b>This Issue</b> :	04/04/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2890 REV B
<b>First Issue</b> :	04/04/2008	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	38044	<b>Drawing Revision</b> :	B
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	<u>JLD 08.04.4</u>	<b>Due Date</b> :	30/04/2008
<b>Comment</b> :	Est. D 05.03.21 Removed Bending procedures KJ/JLM		

Qty: 1 Um: Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6008180	Crosstube extrusion
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part # Description Batch

1 D6008-180 Crosstube extrusion

B34688

EL 8-4-14

2.0	BENDING	BENDING MACHINE - SKIDTUBES
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**Comment:** BENDING MACHINE

1-Bend D2890 as per Dwg D2890 and Folio FT002

EL 8-4-14

3.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

8 28/04/14

4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Deburr and Polish

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a/n S. S. 28/04/14  
 38345  
 used on w/c 28/35

Date: Friday, 04/04/2008 10:52:08 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CROSSTUBE

Job Number: 38400

Part Number: D2890

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

*W/4*  
*08/04/14* *38315*  
*USED on w/o# 38357*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/04/16* *MF*

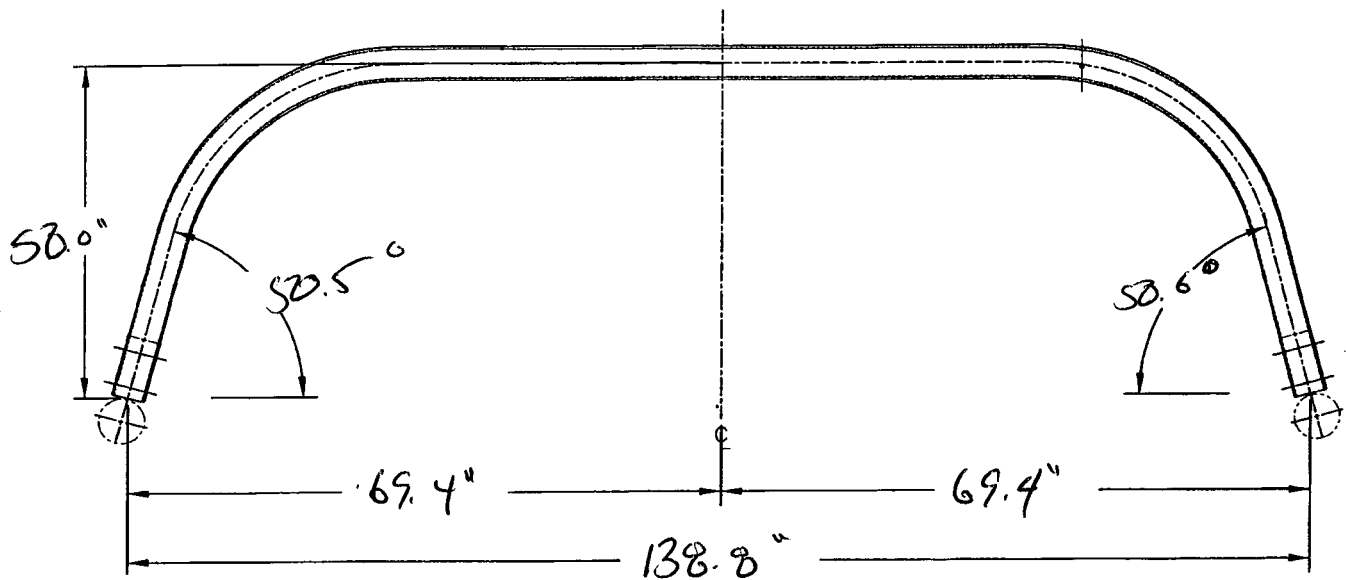
Job Completion



*MF 08-04-16*

DART AEROSPACE LTD		Work Order:	38400
Description: Crosstube Aft		Part Number:	D2890
Inspection Dwg: D2890		Rev: B	Page 1 of 1

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments
* used on w/o # 38357 38355

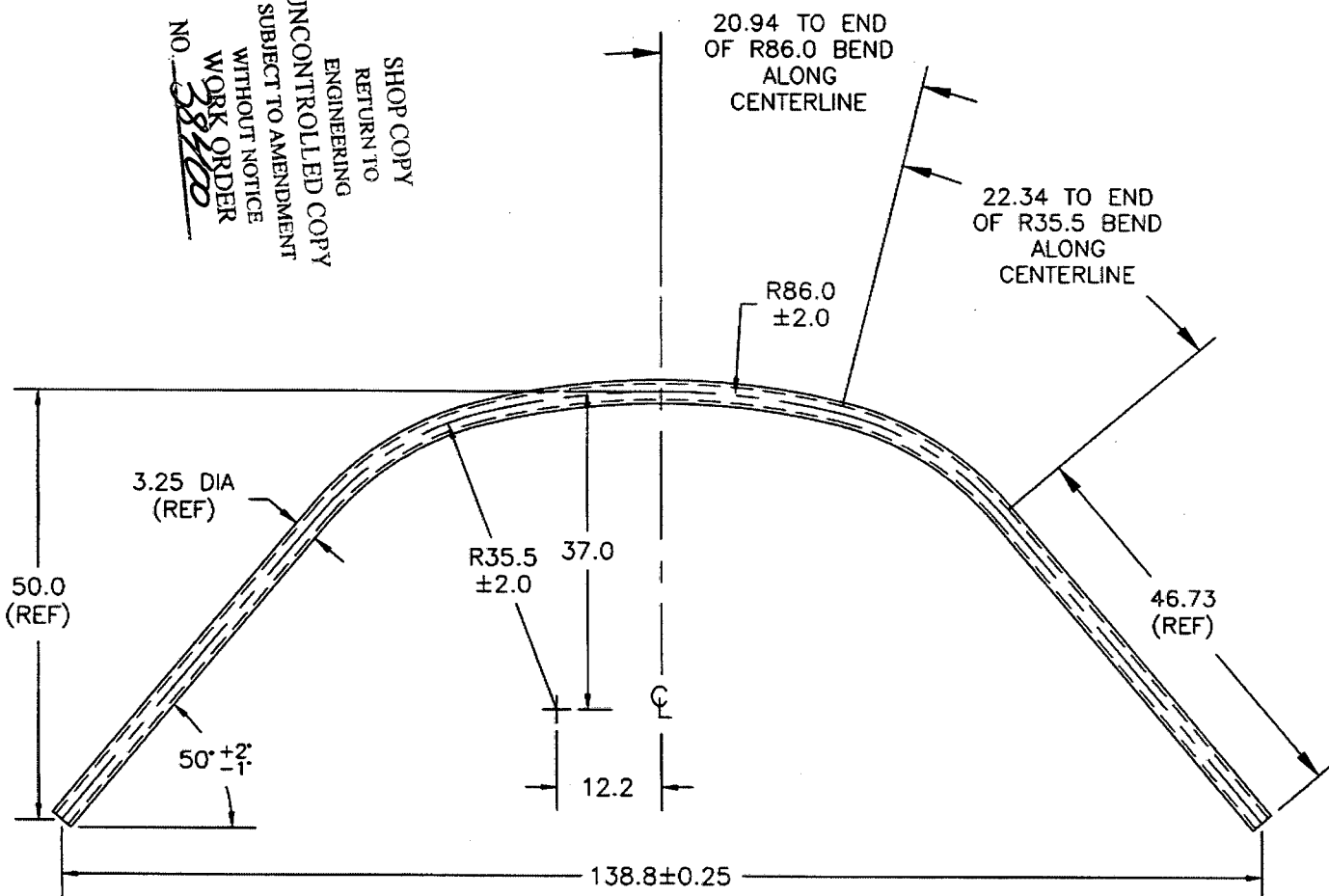
QC15 Inspection	
Date	08/04/14

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	



RELEASED  
02.10.28

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. B
02.10.18	AFT CROSS TUBE	SHEET 1 OF 1
A	99.05.21	SCALE
B	02.10.18	1:20
ADD TANGENT LENGTHS; CHANGE NOTES		



#### NOTES

- 1) MATERIAL: MANUFACTURE FROM D6008-180 (ø3.25 OD x 0.438 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

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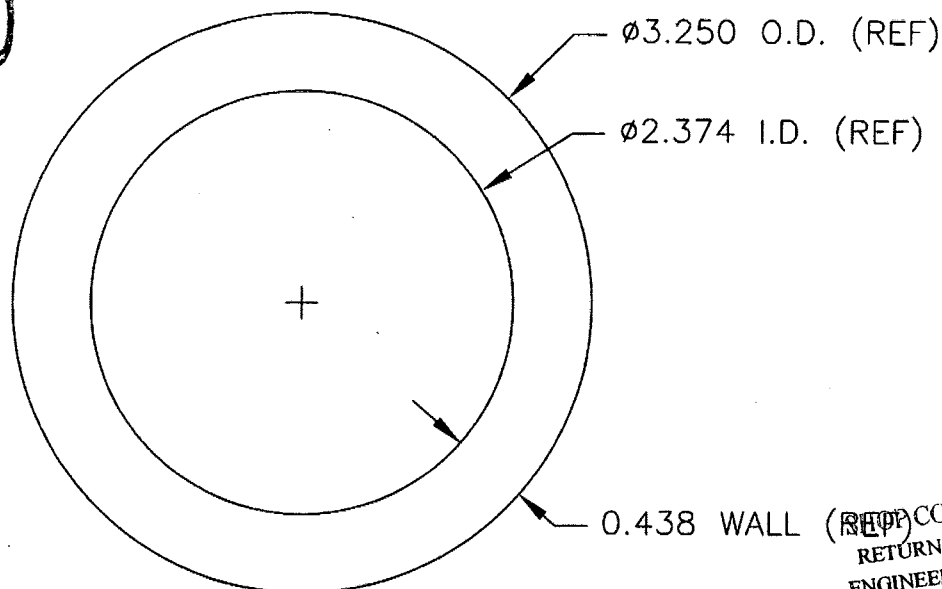
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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6008	REV. A SHEET 1 OF 1
DATE 00.11.17		TITLE CROSSTUBE MATERIAL SCALE 1:1	
A	00.11.17	NEW ISSUE	

## SPECIFICATION CONTROL DRAWING

**RELEASED**  
00.11.24 *[Signature]*



### NOTES

- 1) D6008-XXX CROSSTUBE  
LENGTH

WHERE XXX IS LENGTH IN INCHES  
EG. 180" LONG TUBE: D6008-180

- 2) MATERIAL: 3.250 OD x 0.438 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.  
MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi  
MINIMUM YIELD TENSILE STRENGTH = 66 ksi
- 3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:  
O.D.:  $\pm 0.008$  MEAN ( $\pm 0.016$  INCLUDING OVALITY)  
WALL:  $\pm 0.020$  MEAN ( $\pm 0.044$  INCLUDING ECCENTRICITY)  
LENGTH: XXX  $+0.125/-0.000$   
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
- 4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

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